

Date: Monday, 1/14/2008 2:32:45 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BRACKET ASSEMBLY	
Job Number	36735		Part Number	D3183041	
Estimate Number	12453		Drawing Number	D3183 REV C1	
P.O. Number			Project Number	N/A	
This Issue	1/14/2008	S.O. No. :	Drawing Revision	C1	
Prsht Rev.	NC		Material	:	
First Issue	/ /	Type : MACHINED PARTS	Due Date	2/5/2008	Qty: 4 Um: Each
Previous Run					
Written By	:				
Checked & Approved By	:				
Comment	Est Rev:Pick:A 04.02.18 New issue KJ/DS				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M174B2000X01500	17-4 SS Bar	
		Comment: Qty.: 0.4812 f(s)/Unit Total : 1.9249 f(s) Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.500x02.000) Identify for D3183-043 Batch: M19478 DTP 08/02/17 (4) + 1 M19478 DTP 08/02/28 (4) not required from lot 55 (1)	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: (1.500" x 2.000") 4.300" long DTP 08/02/17 (4)	
3.0	HAAS	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine D3183-1 as per Folio FA320 and Dwg D3183 Identify as D3183-1 2-Deburr 3-Scribe batch number DTP 08/02/26 / 8P 08/02/28 (4)	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE 8P 08/02/28 (4)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3183 - 041 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: Date: 08/03/20 QA: N/C Closed: Date: 08/03/24

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/27	3.0	H24 offset was not adjusted with tool #4. The center drill has marked the part. L.C.: operator error	J vasiuk	Scraped: replace QTY 1 in 19478	DSP 08/02/28	S.F 08/02/28	/	/

NOTE: Date & initial all entries

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Drawing Name: BRACKET ASSEMBLY

Job Number: 36735

Part Number: D3183041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 08/02/79

6.0 D312121 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3121-21 Bolt B 37478 x8

ml

7.0 D3183045 Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3183-045 Bearing Ass B 36638 x2 B 38104

ml

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3183-041 as per Dwg D3183.

+ Scribe.

08/03/19 (4)

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/19 (xv)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 233A

8/3/19 sc (4x)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/20 (4)

Job Completion



2008/3/20

(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36735
Description: Bracket	Part Number:	D3183-1
Inspection Dwg: D3183 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	.402	/			
0.182	+/-0.010	.179	/			
0.070	+/-0.010	.071	/			
0.100	+/-0.010	.110	/			
R0.063	+/-0.010	.063	/			
R0.189	+/-0.010	.189	/			
3.881	+/-0.010	3.879	/			
4.17	+/-0.030	4.179	/			
0.830	+/-0.010	.830	/			
0.500	+/-0.010	.501	/			
0.218	+/-0.010	.215	/			
1.030	+/-0.010	1.032	/			
1.90	+/-0.030	1.895	/			
1.012	+/-0.010	1.008	/			
0.786	+/-0.010	.789	/			
R0.19	+/-0.010	.190	/			
Ø0.392	+0.002/-0.000	.393	/			
0.162	+/-0.010	.164	/			
2.799	+/-0.010	2.800	/			
2.075	+/-0.010	2.075	/			
0.162	+/-0.010	.164	/			
0.032	+/-0.010	.030	/			
0.381	+/-0.010	.390	/			
0.200	+/-0.010	.195	/			

Measured by:	J.A.	Audited by:	J.L.	Prototype Approval:	N/A
Date:	08/02/28	Date:	08/02/29	Date:	N/A

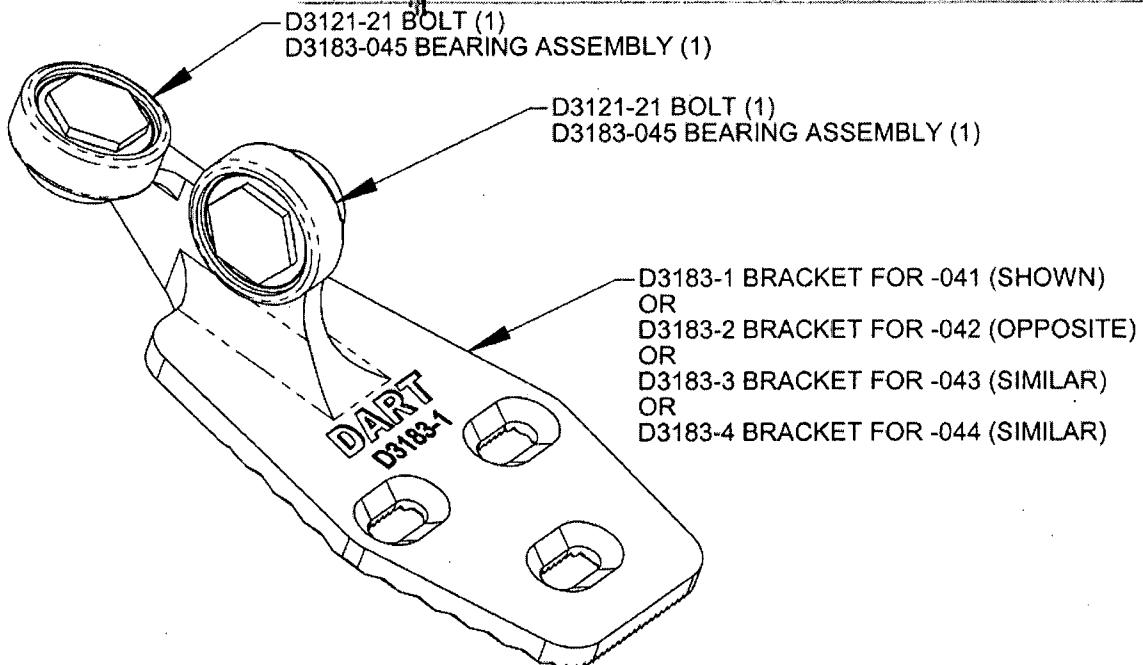
Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3183-041/-042)	KJ/JLM	J.S.

DART

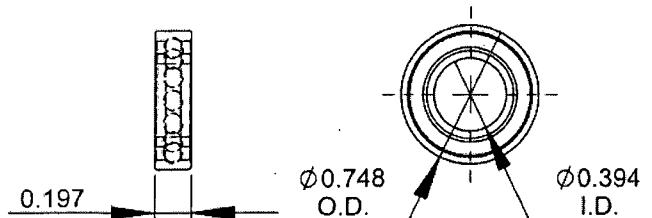
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3183
DATE	04.02.17	REV. C SHEET 1 OF 4 SCALE 1:1 TITLE BRACKET ASSEMBLY

RELEASED

04.03.01

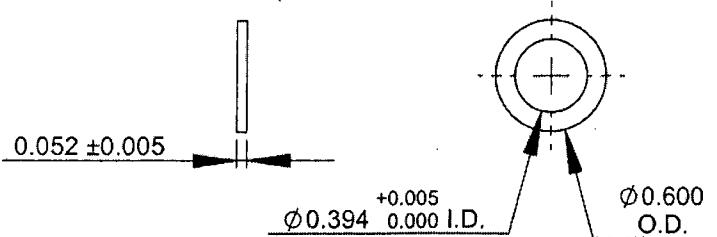


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: **SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE CONRAD TYPE, SHIELDED SHOP COPY
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ RETURN TO ENGINEERING
- 3) ALL DIMENSIONS ARE IN INCHES UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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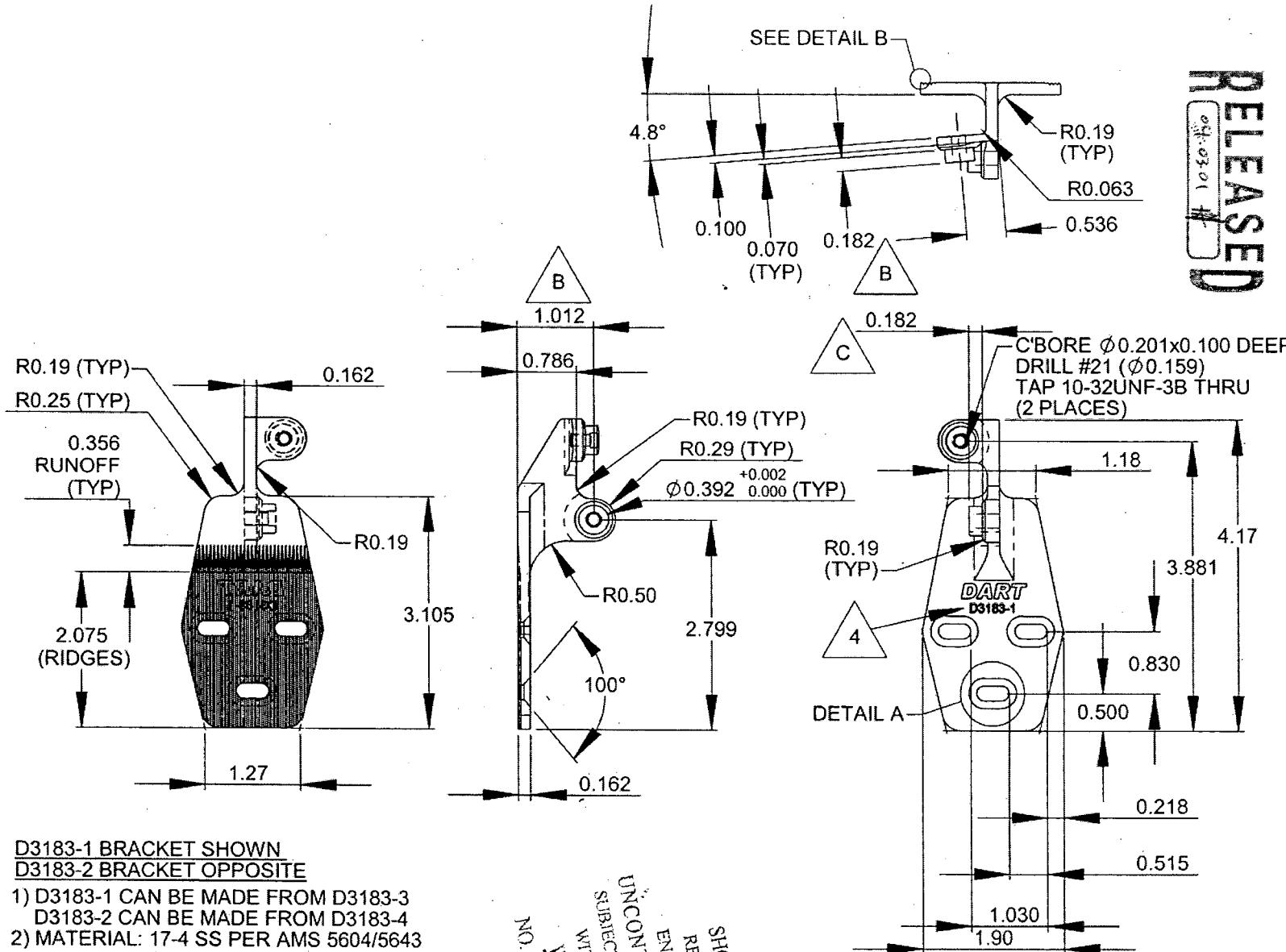
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		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	
		D3183	
DATE	04.02.17	TITLE	
		BRACKET ASSEMBLY	
REV. C		SHEET 2 OF 4	
SCALE	1:2		

RELEASED

04-03-01



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

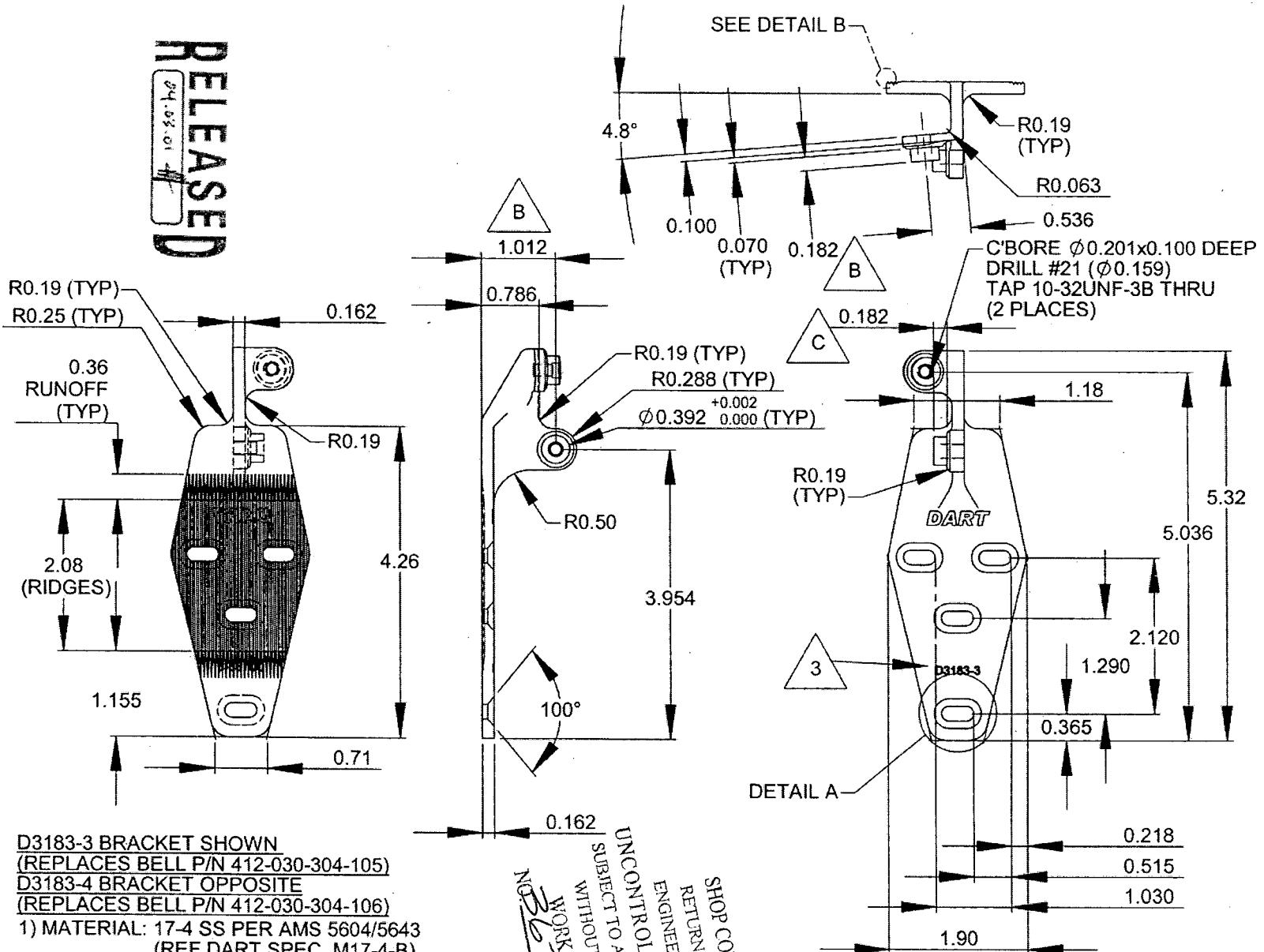
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DATE	04.02.17	DRAWING NO. D3183
TITLE	BRACKET ASSEMBLY	REV. C SHEET 3 OF 4 SCALE 1.2

RELEASED
JH 03.01



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)

D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi

2) BREAK ALL SHARP EDGES 0.005 TO 0.015

3) ENGRAVE DART P/N & LOGO AS SHOWN

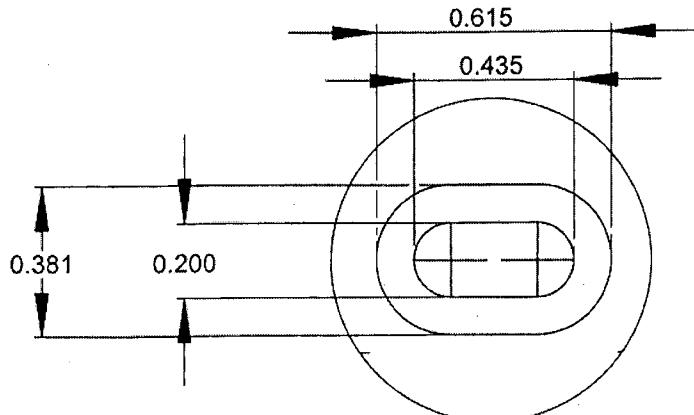
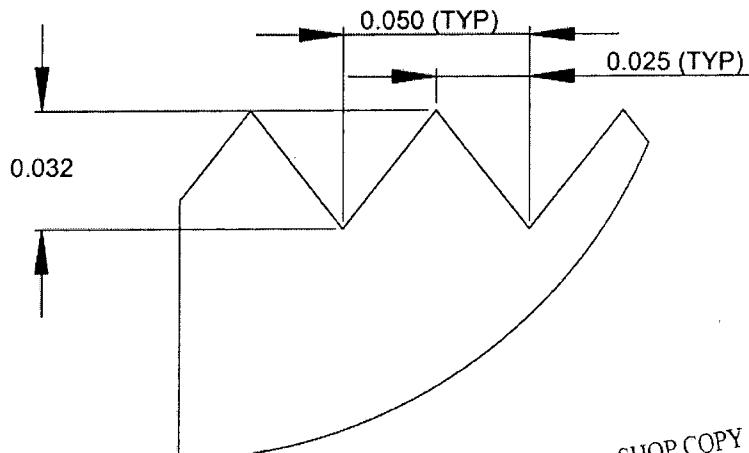
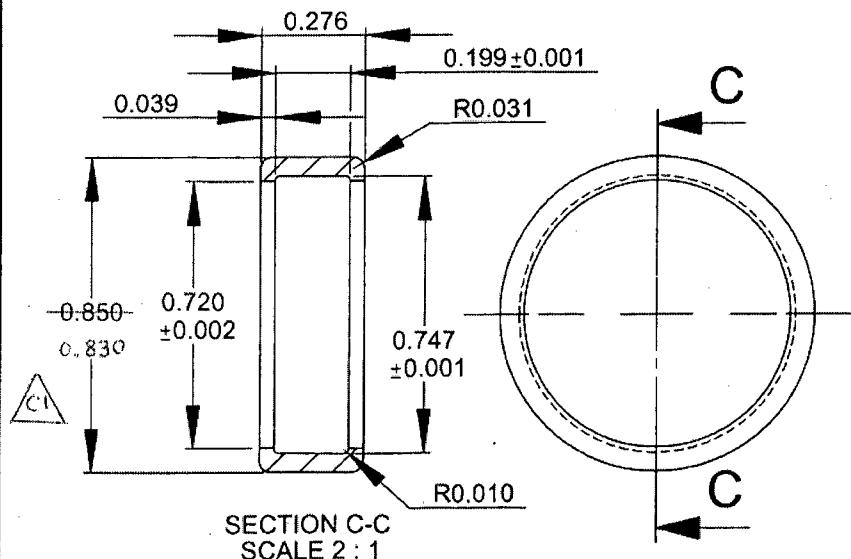
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

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DESIGN	DRAWN BY
CHECKED	APPROVED
DATE	04.02.17

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADAREV. C
SHEET 4 OF 4
SCALE
1:1DETAIL A (2 : 1)**RELEASED**
04.03.01DETAIL B (20 : 1)SECTION C-C
SCALE 2 : 1

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36735

D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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